

Date: Friday, 10/12/2007 1:11:57 PM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 35158
 Estimate Number : 11474
 P.O. Number : *N/A*
 This Issue : 10/12/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *MA* Type : SMALL /MED FAB
 Previous Run : 27374

Drawing Name : DOUBLER
 Part Number : D3140303
 Drawing Number : D3140 REV F
 Project Number : N/A
 Drawing Revision : F
 Material : *N/A*
 Due Date : 10/19/2007

Qty: *78* Um: Each

Written By : *MA*
 Checked & Approved By : *MA*
 Comment : Est. rev A 02.11.06 New issue
 Est. Rev B 06.04.18 New dwg rev. ecn781
 EST rev.C 06.04.25 Waterjet
 Est. rev.D added scuffing NCR 061 EC
 Est Rev:E As per ECN #829 06-11-20 JLM

KJ/RF
 EC
 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S063 *204732063* 6061-T6 .063 Sheet



Comment: Qty.: 2.9166 sf(s)/Unit Total : 5.8332 sf(s)
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063)
 Batch: *M105916* *IB 07-10-15*

2.0 WATER JET FLOW WATER JET



P10

Comment: FLOW WATER JET
 1-Cut as per Dwg D
 Dwg Rev: *F* *IB 07-10-15*
 Prog Rev: *F*
 2-Deburr if necessary *IB 07-10-15*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK *IB 07-10-15*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 7/10/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/16	11	7 parts were made out of 2024 T3 instead of 6061 T6. RC! Human error	UE 07.10.16 Q51042	Accepted for this time only	UE 07.10.16 Q51042	✓ 07/10/17	UE 07.10.16 Q51042	En 7/10/16

NOTE: Date & initial all entries

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Drawing Name: DOUBLER

Job Number: 35158

Part Number: D3140303

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Scuff surfaces with 80grit sandpaper per QSI 006

2-Deburr.

No sharp edges

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



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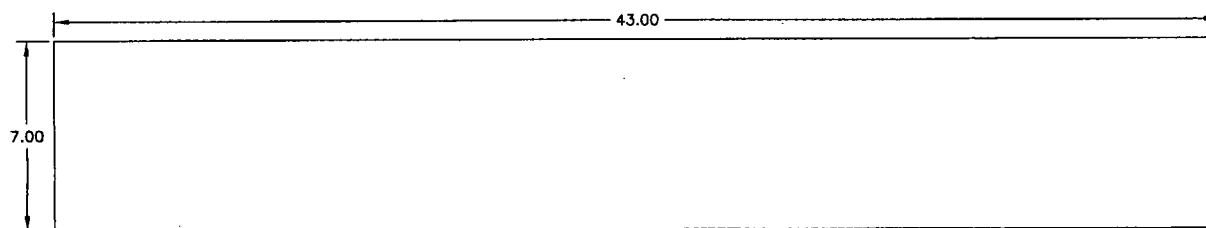
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

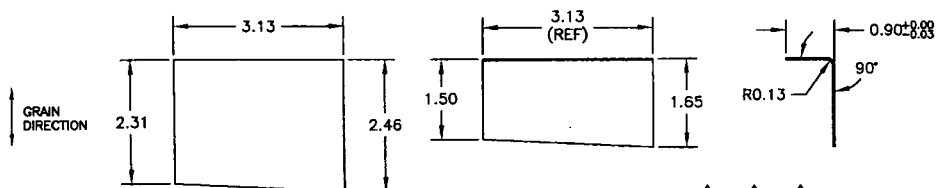
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

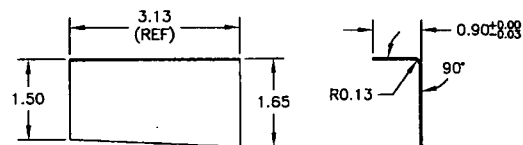
NOTE: Date & initial all entries



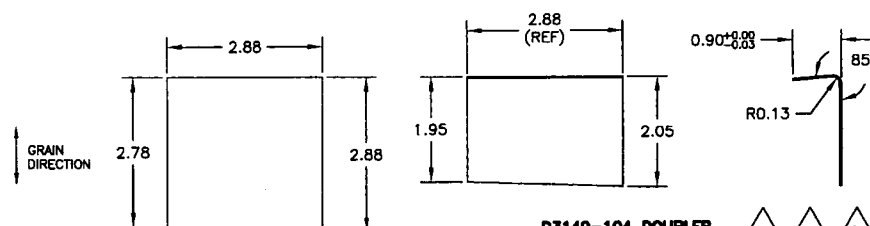
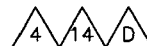
D3140-87 DOUBLER
(REPLACES PREMIER P/N B30-23000-87)



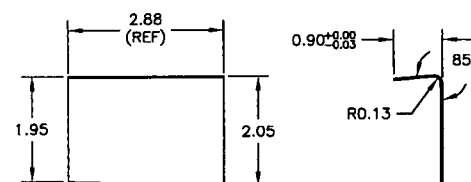
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



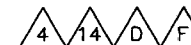
D3140-105 DOUBLER
(REF)
D3140-106 OPPOSITE



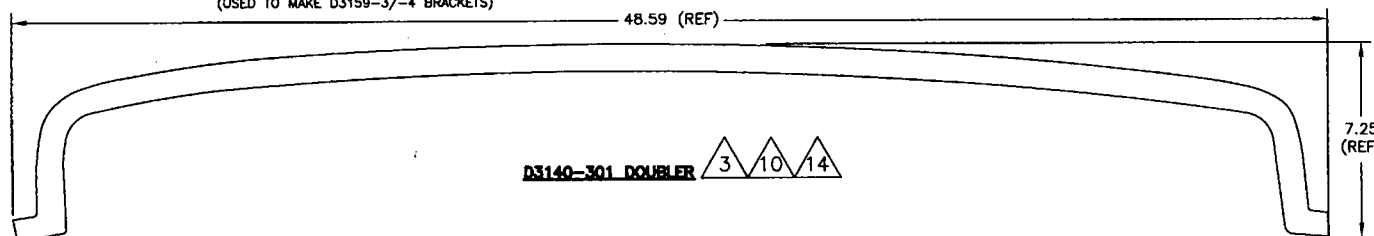
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



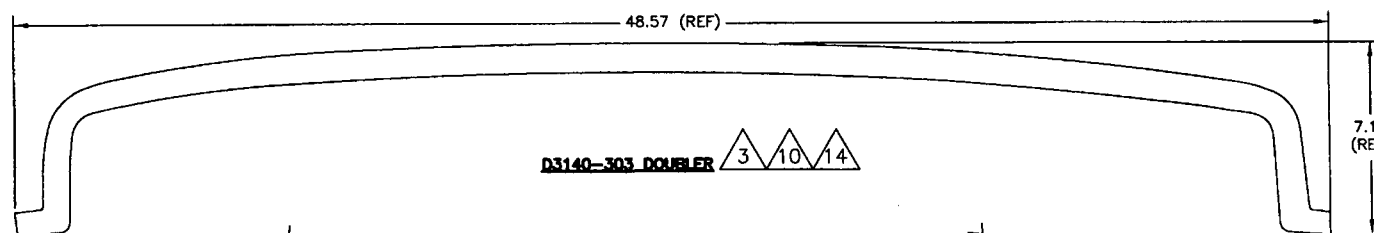
D3140-104 DOUBLER
D3140-103 OPPOSITE



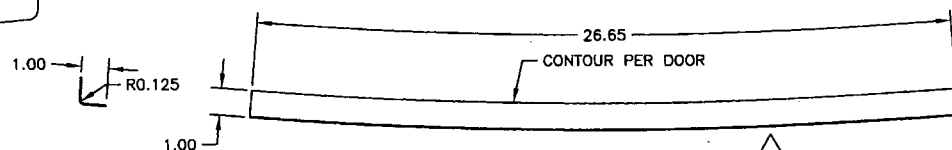
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3140-301 DOUBLER



D3140-303 DOUBLER



D3140-85 ANGLE
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

RELEASED

06.10.13

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CHECKED 	APPROVED 	DRAWING NO. D3140		REV. F SHEET 6 OF 7
DATE 06.10.06		TITLE DOOR		SCALE MTS

